Work Order 1 Tuesday, July 29, 20			*123	3123*							Page 1
Item ID: D3 Revision ID:	462-1	·	Accept	*N900	040	10	N *	Setup 5	Start	*N:	S1*
Item Name: Bra	cket Assembly								Stop	*N.	30*
Required Date: 7/29	9/14 Start Qty: 8.00 9/14 Req'd Qty: 8.00	* <u>^</u> **		Cust Item I	ID:					1 01	17
	ocess Plan: J. U		30 Tooling:	D	ate:	_]		Start Ston	*NF	₹1*
QO	C:	Date:	SPC (Y/N):	D	ate:			•	Stop	*NF	32*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject	Insp. Stamp
Draw Nbr	Revision Nbr		- All								
D3462	Rev C										
100 *1	FLOW WATER JET		0.00	<u> </u>			(B)	· #M		DAS 46	14/08/09
FLOW CNC Waterjet	Memo 1-Cut as po Dwg Rev:	er Dwg D3462	0.00		,						· ·
	Prog Rev: 2-Deburr	f necessary									
110 *1 1 0 *	QC2- Inspect parts off	machine FAI/FAIB	0.00							DAS 46	
*11 0 *	Memo		0.00				(13)			40 -89-	14/08/0

0.00

Memo

Quality Control

DQA:			Date:						_					"DART
OA Classel			Data			WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	ndate only	\neg	AEROSPACE
QA Closed:			Date:		-	<u> </u>					ork Order up	date only		
Work Orde	r.					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
Work Orac	- ' '					Rework	1		Skid-tube	Crosstube		Water Jet	\Box	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
	_					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	re/Packaging[Other
NCR N	lo.					Suspected Unapproved]		Large Fab	Composite		Supplier[
												·		
Root					Desci	ription of work order update	1	nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	1	QC Inspector
Design	_													
Doc/Data													l	
Equip/Tooling							İ							
Handling/Pre	. 1													
Material	_						ļ							<i>,</i>
Operator														
Offset/Setup	_												ı	
Process	_	,												
Supplier	\dashv													
Training							1							
Transport														
Unapproved	\perp		<u> </u>	<u> </u>	<u> </u>			LUT CA	TECODY		<u> </u>			
			<u>-u</u>				FA	ULI CA	TEGORY					
Landir T	$\overline{}$					General		احمانه ره	Program		Outside Dim	ensions [Pressure/Forced
	—	Bending	-+ Camaaa		<u> </u>	Bend BOM/Route	\vdash	Grain	riograffi		Over/Under		—┥	Set-up
}	-	Centre No	ot Concer	itric		Broken/Damage/Defect	\vdash	Hardwa	aro.	-	Part Incorred	ł	-	Temperature/Cure
}		Cracks Crimp/Kir	ak/Binnlo	Maya	-	Burrs	-	4	ion Incomplete/Un	ogualified -	Part Lost/Mi	†	-	Weld
}	-	Cuffs	IK) Kihbie	y wave	-	Contamination	\vdash	4	tions Incomplete/U		Part Moved			Wrong Stock Pulled
		Crushing			-	Countersink	\vdash	4	gned/off center	-	Positioned V	เ Vrong		
		Heat Trea	at .			Cut Too Short	-	Mislab		<u></u>	Power Loss/			Other
}	_	Inspection		Tube		Drawing		Misrea		L		~ (
}	\blacksquare	Marks/Ch			<u> </u>	Drill Holes	 	Off-set						
	-	Turning S				Finish		4	Calibration					
	-	Wave/Tw				Fit/Function		-1	Sequence					

Work Order ID 123123 *123123* Page 2 Tuesday, July 29, 2014 2:31:56 PM Item ID: D3462-1 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Bracket Assembly **Start Date:** 7/29/14 **Start Oty: 8.00 ***2* **Cust Item ID:** Required Date: 7/29/14 Req'd Otv: 8.00 *****2* Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: NP2* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID **Description Run Hours** Qty Code Oty Number Stamp 120 QC8- Inspect parts - second check 0.00 *120* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 1/1/ACOQ 150 DAS *150* 28 _/3x AUG 1 1 2014 Packaging 0.00 Memo Packaging *****STOCK IN LARGE FAB*****

160

QC21- Final Inspection - Work Order Release

0.00

160 OC.

Quality Control

WR2 14-08-15

Memo

0.00

DQA:	-		Date:			. WORK ORDER NON	~	SNIFO	DAAANCE / 111	DDATE				PT
QA Closed:			Date:			WORK ORDER NON	-00	JNFO	RIVIAINCE / UI		ork Order up	date only	AEROSP	ACE
						DISPOSITION				AGAINST DI	PARTMENT	PROCESS		
Work Ord	er: .					Rework	ıİ		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	No.					Scrap			Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	e/Packaging	Other	
NCR I	No.				 .	Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspect	or
Design														
Doc/Data														
Equip/Tooling	Ш													
Handling/Pre	Ш													
Material	Ш													
Operator														
Offset/Setup]				l							
Process	Щ													
Supplier														
Training											İ			
Transport														
Unapproved	L	<u> </u>		<u> </u>					<u> </u>	·				
							FA	ULT CA	regory					
Landi	_	1			_	General	_	1		Г	٦	Г	¬	J
		Bending			\vdash	Bend	<u> </u>	-	Program	_	Outside Dim	-	Pressure/Forced	ג
		1	ot Concer	ntric		BOM/Route	\vdash	Grain		├	Over/Under	—	Set-up	
	<u> </u>	Cracks			_	Broken/Damage/Defect	<u> </u>	Hardwa		 	Part Incorre	⊢	Temperature/C	ure
	-	Crimp/Ki	nk/Ripple	/Wave		Burrs	<u> </u>	-l '	ion Incomplete/U	· -	Part Lost/M	ssing	Weld	llad
	<u> </u>	Cuffs			_	Contamination	\vdash	-	tions Incomplete/l	Jnclear	Part Moved	L.	Wrong Stock Pu	illea
	<u> </u>	Crushing			<u> </u>	Countersink	\vdash	- '	gned/off center	<u> </u>	Positioned V		Other	
,	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislab		<u>L</u>	Power Loss/	ourge [Tottler	
	<u> </u>	4	n Strip in	ľube	<u> </u>	Drawing	\vdash	Misrea						-
	<u> </u>	Marks/Cl			<u> </u>	Drill Holes	_	Off-set						
	<u> </u>	1	Sequence		<u> </u>	Finish	_	-	Calibration					
l	1	Wave/Tv	vist in Tub	oe -		Fit/Function		Out of	Sequence					

Work Order ID: 123123

123123

TPI

Parent Item:

D3462-1

D3462-1

Parent Item Name:

Bracket Assembly

Start Date: 7/29/14

Required Date: 7/29/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV. A 05.11.18 NEW ISSUE EC IPP Rev:B Now on Waterjet 06-06-16 JLM

esr rev B 08.07.15 ecn 1049 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No	-		100	sf	197.5632	0.095	1	DAS		
M304S11 304/316 0.125 Sheet	IGA								**	. <u> </u>	46 9-89		14/08/0
				Location		Loc (<u>Oty</u>	Loc Code					
				MAT020		1	29.3						
					122521		29				_		

M129545

100.3 68.2631604 68.2631604

DQA:			Date:						2244465 / 115	ND 4 TE			•	`DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFOI	RMANCE / UF		ork Order up	odate only	٦	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orde	er: _					Dist ostition				_	<i>,</i> ,	_	_	
						Rework			Skid-tube	Crosstube	_	Water Jet	-	Engineering
Part I	Νο					Scrap			Machining	Small Fab		d. Eng. Coor.	_	Quality
NCR I	No.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	\dashv	Other
NCKI	١٠٠.					Suspected Onapproved			carge ras					
Root					Desc	ription of work order update	1	nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	\perp	QC Inspector
Design														
Doc/Data	Ш													
Equip/Tooling	Ш				_									
Handling/Pre	Щ								1					
Material	Ш	:												
Operator	Щ													
Offset/Setup	Щ													
Process	Ш											:		
Supplier														
Training														
Transport			:		,	:								
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng (1			_	General	_	1			7	. г	٦,	/F
		Bending			<u> </u>	Bend	┝	4	rogram	<u> </u>	Outside Dim	<u> </u>		essure/Forced
		ł	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		_	Over/Under	<u> </u>	_	et-up
	$ldsymbol{ldsymbol{eta}}$	Cracks			-	Broken/Damage/Defect		Hardwa			Part Incorred	<u> </u>		mperature/Cure
	ldash	Crimp/Ki	nk/Ripple	/Wave	-	Burrs	\vdash	- '	ion Incomplete/Un	· -	Part Lost/Mi	ssing	_	eld
		Cuffs			<u> </u>	Contamination		4	tions Incomplete/U	Inclear	Part Moved	L	_ J™	rong Stock Pulled
		Crushing				Countersink	\vdash	-	gned/off center	<u> </u>	Positioned V		٦	sh a u
	<u> </u>	Heat Trea				Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	IOI	ther
		Inspectio		Tube	<u> </u>	Drawing	\vdash	Misrea						
		Marks/Cl			<u> </u>	Drill Holes	-	Off-set						
		4	Sequence			Finish		-	Calibration					
		Wave/Tv	vist in Tub	oe -		Fit/Function	<u></u>	Out of	Sequence					

D3065-5DART AEROSPACE LTD	Work Order:	123123
Description: Base	Part Number:	D3462-1
Inspection Dwg: D3462 Rev: C		Page 1 of 1

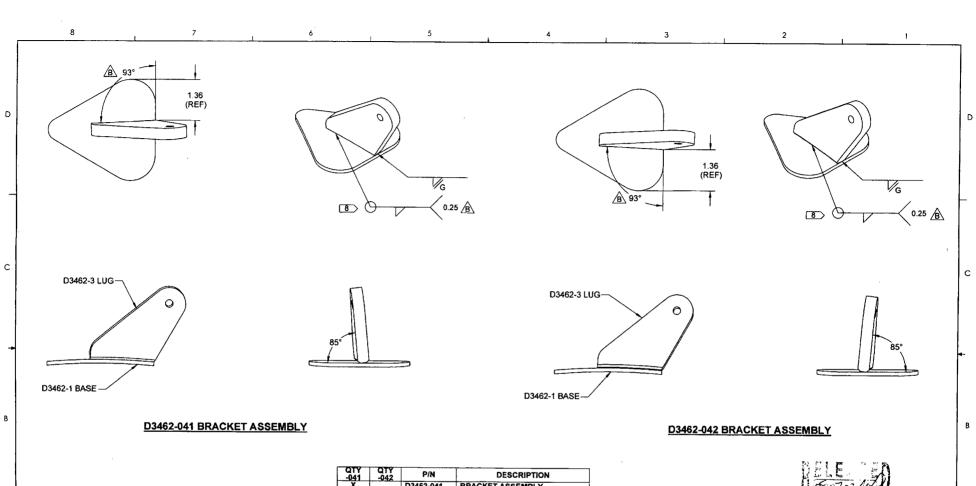
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.58	+/-0.030	3.59			v-Slem.d	
3.36	+/-0.030	3.35	/			
0.125	+/-0.010	0.117	V			
				,		
-			1			
			-	-		
	-					
						- Annual - Especial -
	DAS		DAS			

	<u> </u>		39		
Measured by:	9-89	Audited by:	9-89	Prototype Approval:	N/A
Date:	14/08/09	Date:	14/08/11	Date:	N/A

Į	Rev	Date	Change	Revised by	Approved
Į	Α	07.09.06	New Issue	KJ/JLM 140	
	В	08.07.24	Dimensions updated per Dwg Rev C	KJ/DD	7
_				· · · · · · · · · · · · · · · · · · ·	



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	Х	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
 USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.75 lbs (TYP)
 8) WELDING: PER DART QSI 004



14/07/30

`			100,53				
С	SHOW	VIEWS OF D34 ON: PRODUCTION	62-041 & D3462-042, UPDATE DWG DN FACILITY	DC	07.10.24		
В	REVIS	E DIMENSIONS	RF	05.12.05			
Α	NEW I	SSUE	RF	05.09.20			
REV.	DESC	RIPTION		BY	DATE		
DESIG	N	_	DART AEROSPA	ACEL	TD		
DRAW	DRAWN MANDE			HAWKESBURY, ONTARIO, CANADA			
CHECH	ŒD	100	DRAWING NO.		REV C		

DRAWN	MANDO	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NP	DRAWING NO.	REV. C
MFG. APPR.	200	D3462	SHEET 1 OF 2
APPROVED	1/10	TITLE	SCALE
DE APPR.	#	BRACKET ASSEMBLY	1:2
DATE 07.10.24		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE OCCUPATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF OTHER ANY PURPOSE TO LOVE OF THE SAME THE PURPOSE OF THE PURPOSE O	

